AMENDMENT TO THE CLAIMS

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims

Claims 1. – 97. (*Canceled*).

98. (*Previously presented*) Machine for producing a multilayer paper or board web, comprising:

at least two gap formers structured to form at least two layers having a higher content of fines on one side;

a couching zone in which the at least two layers ~~to be~~ are couched with each other;

the at least two gap formers are arranged so that the one side of each of the at least two layers having the higher content of fines fed to the couching zone in such a way that the one sides of the at least two layers having the higher content of fines come into contact with each other;

the at least two gap formers each comprises a forming roll, a forming shoe, and two circulating endless dewatering belts, the two circulating belts being arranged to run together forming a stock inlet arranged to be charged with a fibrous suspension from a headbox and an adjoining twin-wire zone, the charged stock inlet being led over the forming roll, whereby the one side with the higher content of fines is located on the forming roll side, and, starting immediately from the forming roll, the twin-wire zone runs downwards in such a manner that the forming shoe rests on the upper dewatering belt.

99. (*Previously presented*) Machine according to Claim 98, wherein ~~the~~ belt running directions of the at least two gap formers are opposite to each other.

100. (*Previously presented*) Machine according to Claim 99, wherein the two dewatering belts are arranged as an inner and an outer dewatering belt relative to the forming roll, and wherein the layer formed in a first of the two gap formers, together with at least one of the two dewatering belts arranged as an endless belt, is led around a deflection element, and then is fed, via the endless belt, to the relevant couching zone in a direction generally opposite to a jet direction of the first headbox, in which couching zone the layers formed by the two gap formers are couched with their sides of higher fines content together.

101. (*Previously presented*) Machine according to Claim 100, wherein the layer formed in the first gap former, together with the outer dewatering belt not coming into contact with the forming roll, is led around the deflection element and is fed to the couching zone by means of this outer dewatering belt.

102. (*Previously presented*) Machine according to Claim 101, wherein both dewatering belts in the first gap former are led around the deflection element and, after the deflection element, the inner dewatering belt is separated from the outer dewatering belt, which carries the layer with it.

103. (*Previously presented*) Machine according to Claim101, wherein, after the deflection element, the outer dewatering belt of the first gap former is led generally in the horizontal direction, at least as far as a region of the couching zone.

104. (*Previously presented*) Machine according to Claim 100, wherein a further layer is formed by a Fourdrinier former and the sheet formation of the further layer is carried out to attain a higher contents of fines on an outer side facing away from a Fourdrinier wire, in that the layer formed in the first gap former and led over the deflection element is couched together with the layer formed by the Fourdrinier former, and in that these two layers are fed to the couching zone by the Fourdrinier wire, in which couching zone the layers formed by the two gap formers are couched with their sides of higher fines content together.

105. (*Previously presented*) Machine according to Claim 104, wherein the outer dewatering belt of the first gap former is separated from the inner dewatering belt and the layer before the deflection element in the belt running direction, and the layer is only led around the deflection element together with the inner dewatering belt.

106. (*Previously presented*) Machine according to Claim 104, wherein the layer formed in the Fourdrinier former and the layer formed in the first gap former are couched with each other in a region of at least one of the deflection element and a couch roll.

107. (*Previously presented*) Machine according to claim 98, wherein, in a second of the two gap formers relative to a web run direction, the two dewatering belts are arranged as an inner and an outer dewatering belt relative to the forming roll, and

wherein, after a separation of the two dewatering belts of the second gap former, the layer formed by the second gap former, together with the outer dewatering belt, is fed to the couching zone, in which the two layers formed in the two gap formers are couched with their sides of higher fines content together.

108. (*Previously presented*) Machine according to Claim 98, wherein a further layer to be couched is formed by a Fourdrinier former and the sheet formation of the further layer is carried out with a higher content of fines on the outer side, facing away from a Fourdrinier wire, and

wherein the outer side of the further layer having the higher content of fines is couched with the layers from the two gap formers.

109. (*Previously presented*) Machine according to Claim 108, wherein a jet direction of the headbox of at least one of the two gap formers corresponds generally to a running direction of the further layer formed by the Fourdrinier former.

110. (*Previously presented*) Machine according to Claim 108, wherein, in a first

of the two gap formers relative to a web run direction, the two dewatering belts are arranged as an inner and an outer dewatering belt relative to the forming roll, and

wherein, after a separation of the two dewatering belts of the first gap former, the layer formed by the first gap former, together with the outer dewatering belt, is fed to the couching zone, in which the outer dewatering belt is led together with the Fourdrinier wire in order to couch the two layers.

111. (*Previously presented*) Machine according to Claim 108, wherein the Fourdrinier wire is preferably led generally in the horizontal direction, at least in the region of the couching zone.

112. (*Previously presented*) Machine according to claim 98, wherein, in order to form an at least three-layer fibrous web, at least one additional gap former is provided and a sheet formation of the additional layer is attained with a higher content of fines on a forming element side, and in that the higher content of fines of the additional layer is couched in an additional couching zone with the layers formed by the two gap formers, at least one of the two layers being couched with the other layer with a side of higher fines content.

113. (*Previously presented*) Machine according to Claim 112, wherein a jet direction of the headbox assigned to the additional gap former corresponds to a running direction of the fibrous web to be formed.

114. (*Previously presented*) Machine according to claim 98, wherein the headbox associated with each of the two gap formers comprises at least one multilayer headbox, at least one single-layer headbox, and a combination of different headboxes.

115. (*Previously presented*) Machine according to claim 98, wherein the headbox associated with each of the two gap formers comprises at least one single-layer headbox.

116. (*Previously presented*) Machine according to claim 98, wherein equal pressure dewatering elements are provided for belt dewatering.

117. (*Currently amended*) Process for producing a multilayer paper or board web, comprising:

forming at least two layers with at least two gap formers, the at least two layers to being formed to have one side a higher fines content;

couching together the at least two layers in a manner that the one sides of the at least two layers having the higher content of fines come into contact with each other;

wherein the at least two gap formers each comprises a forming roll, a forming shoe, and two circulating endless dewatering belts, the two circulating belts being arranged to run together, forming a stock inlet arranged to be charged with a fibrous suspension from a headbox and an adjoining twin-wire zone;

the method further comprising:

charging the stock inlet with the fibrous suspension and leading the charged stock inlet over the forming roll, whereby the one side with the higher content of fines is located on the forming roll side, and

starting immediately from the forming roll, leading the at least two layers in the twin-wire zone downward and in such a manner ~~to lead~~ the forming shoe rests on the upper dewatering belt.

118. (*Previously presented*) Process according to Claim 117, wherein the two gap formers are arranged with opposite belt running directions.

119. (*Previously presented*) Process according to Claim 118, wherein the two dewatering belts are arranged as an inner and an outer dewatering belt relative to the forming roll, and wherein the layer formed in a first of the two gap formers, together with at least one of the two dewatering belts arranged as an endless belt, is led around a deflection element, and then is fed, via the endless belt, to the relevant couching zone in a direction generally opposite to a jet direction of the first headbox, in which couching zone the layers formed by the two gap formers are couched with their sides of higher fines content together.

120. (*Previously presented*) Process according to Claim 119, wherein the layer formed in the first gap former, together with the outer dewatering belt not coming into contact with the forming roll, is led around the deflection element and is fed to the couching zone by

means of this outer dewatering belt.

121. (*Previously presented*) Process according to Claim 120, wherein both dewatering belts in the first gap former are led around the deflection element and, after the deflection element, the inner dewatering belt is separated from the outer dewatering belt, which carries the layer with it.

122. (*Previously presented*) Process according to Claim 121, wherein a further layer is formed by a Fourdrinier former and the sheet formation of the further layer is carried out to attain a higher contents of fines on an outer side facing away from a Fourdrinier wire, in that the layer formed in the first gap former and led over the deflection element is couched together with the layer formed by the Fourdrinier former, and in that these two layers are fed to the couching zone by the Fourdrinier wire, in which couching zone the layers formed by the two gap formers are couched with their sides of higher fines content together.

123. (*Previously presented*) Process according to Claim 122, wherein the outer dewatering belt of the first gap former is separated from the inner dewatering belt and the layer before the deflection element in the belt running direction, and the layer is only led around the deflection element together with the inner dewatering belt.

124. (*Previously presented*) Process according to Claim 122, wherein the layer

formed in the Fourdrinier former and the layer formed in the first gap former are couched together in a region of at least one of the deflection element and a couch roll.

125. (*Previously presented*) Process according to one of Claims 117, wherein, in a second of the two gap formers relative to a web run direction, the two dewatering belts are arranged as an inner and an outer dewatering belt relative to the forming roll, and

wherein, after a separation of the two dewatering belts of the second gap former, the layer formed by the second gap former, together with the outer dewatering belt, is fed to the couching zone, in which the two layers formed in the two gap formers are couched with their sides of higher fines content together.

126. (*Previously presented*) Process according to Claim 117, wherein a further layer to be couched is formed by a Fourdrinier former and the sheet formation of the further layer is carried out with a higher content of fines on the outer side, facing away from a Fourdrinier wire, and

wherein the outer side of the further layer having the higher content of fines is couched with the layers from the two gap formers.

127. (*Previously presented*) Process according to Claim 126, wherein a jet direction of the headbox of at least one of the two gap formers corresponds generally to a running direction of the further layer formed by the Fourdrinier former.

128. (*Previously presented*) Process according to Claim 126, wherein, in a first of the two gap formers relative to a web run direction, the two dewatering belts are arranged as an inner and an outer dewatering belt relative to the forming roll, and

wherein, after a separation of the two dewatering belts of the first gap former, the layer formed by the first gap former, together with the outer dewatering belt, is fed to the couching zone, in which the outer dewatering belt is led together with the Fourdrinier wire in order to couch the two layers.

129. (*Previously presented*) Process according to Claims 117, wherein, in order to form an at least three-layer fibrous web, at least one additional gap former is provided and a sheet formation of the additional layer is attained with a higher content of fines on a forming element side, and in that the higher content of fines of the additional layer is couched in an additional couching zone with the layers formed by the two gap formers, at least one of the two layers being couched with the other layer with a side of higher fines content.

130. (*Previously presented*) Process according to Claim 129, wherein a jet direction of the headbox assigned to the additional gap former is chosen so as to correspond to a running direction of the fibrous web to be formed.

131. (*Previously presented*) Process according to Claims 117, wherein the

headbox associated with each of the two gap formers comprises at least one single-layer headbox.